

Work Order ID 76179

November-07-11 1:23:28 PM

76179

Page 1

Item ID: D3067-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: End Plate
 Start Date: 07/11/2011 Start Qty: 60.00 ***60*** Cust Item ID:
 Required Date: 21/11/2011 Req'd Qty: 60.00 ***60*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/11/08 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3067	Rev A								

100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3067								
<u>5052 . 063</u>	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

11-11-11

11-11-11

counts

790

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76179

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	NC BRAKE					(90)			
Brake NC	Memo	0.00		SB 11/11/14					
Brake NC	Bend as per Dwg D3067								
140		0.00							
140	QC5- Inspect part completeness to step on W/O					caento			
QC	Memo	0.00		S 11/11/14		(+90)			
Quality Control									
150		0.00							
150	Identify as per dwg & Stock Location: WA					90	φ		
Packaging	Memo	0.00		P 11.11.14					
Packaging	*** STOCK IN STEP CELL***								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3067-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: End Plate

Start Date: 07/11/2011 **Start Qty:** 60.00

60

Cust Item ID:

Required Date: 21/11/2011 **Req'd Qty:** 60.00

60

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation	Description
1	Start at node A
2	Move to node B
3	Move to node C
4	Move to node D
5	Move to node E
6	Move to node F
7	Move to node G
8	Move to node H
9	Move to node I
10	Move to node J
11	Move to node K
12	Move to node L
13	Move to node M
14	Move to node N
15	Move to node O
16	Move to node P
17	Move to node Q
18	Move to node R
19	Move to node S
20	Move to node T
21	Move to node U
22	Move to node V
23	Move to node W
24	Move to node X
25	Move to node Y
26	Move to node Z
27	Move to node AA
28	Move to node AB
29	Move to node AC
30	Move to node AD
31	Move to node AE
32	Move to node AF
33	Move to node AG
34	Move to node AH
35	Move to node AI
36	Move to node AJ
37	Move to node AK
38	Move to node AL
39	Move to node AM
40	Move to node AN
41	Move to node AO
42	Move to node AP
43	Move to node AQ
44	Move to node AR
45	Move to node AS
46	Move to node AT
47	Move to node AU
48	Move to node AV
49	Move to node AW
50	Move to node AX
51	Move to node AY
52	Move to node AZ
53	Move to node BA
54	Move to node BB
55	Move to node BC
56	Move to node BD
57	Move to node BE
58	Move to node BF
59	Move to node BG
60	Move to node BH
61	Move to node BI
62	Move to node BJ
63	Move to node BK
64	Move to node BL
65	Move to node BM
66	Move to node BN
67	Move to node BO
68	Move to node BP
69	Move to node BQ
70	Move to node BR
71	Move to node BS
72	Move to node BT
73	Move to node BU
74	Move to node BV
75	Move to node BW
76	Move to node BX
77	Move to node BY
78	Move to node BZ
79	Move to node CA
80	Move to node CB
81	Move to node CC
82	Move to node CD
83	Move to node CE
84	Move to node CF
85	Move to node CG
86	Move to node CH
87	Move to node CI
88	Move to node CJ
89	Move to node CK
90	Move to node CL
91	Move to node CM
92	Move to node CN
93	Move to node CO
94	Move to node CP
95	Move to node CQ
96	Move to node CR
97	Move to node CS
98	Move to node CT
99	Move to node CU
100	Move to node CV
101	Move to node CW
102	Move to node CX
103	Move to node CY
104	Move to node CZ
105	Move to node DA
106	Move to node DB
107	Move to node DC
108	Move to node DD
109	Move to node DE
110	Move to node DF
111	Move to node DG
112	Move to node DH
113	Move to node DI
114	Move to node DJ
115	Move to node DK
116	Move to node DL
117	Move to node DM
118	Move to node DN
119	Move to node DO
120	Move to node DP
121	Move to node DQ
122	Move to node DR
123	Move to node DS
124	Move to node DT
125	Move to node DU
126	Move to node DV
127	Move to node DW
128	Move to node DX
129	Move to node DY
130	Move to node DZ
131	Move to node EA
132	Move to node EB
133	Move to node EC
134	Move to node ED
135	Move to node EE
136	Move to node EF
137	Move to node EG
138	Move to node EH
139	Move to node EI
140	Move to node EJ
141	Move to node EK
142	Move to node EL
143	Move to node EM
144	Move to node EN
145	Move to node EO
146	Move to node EP
147	Move to node EQ
148	Move to node ER
149	Move to node ES
150	Move to node ET
151	Move to node EU
152	Move to node EV
153	Move to node EW
154	Move to node EX
155	Move to node EY
156	Move to node EZ
157	Move to node FA
158	Move to node FB
159	Move to node FC
160	Move to node FD
161	Move to node FE
162	Move to node FF
163	Move to node FG
164	Move to node FH
165	Move to node FI
166	Move to node FJ
167	Move to node FK
168	Move to node FL
169	Move to node FM
170	Move to node FN
171	Move to node FO
172	Move to node FP
173	Move to node FQ
174	Move to node FR
175	Move to node FS
176	Move to node FT
177	Move to node FU
178	Move to node FV
179	Move to node FW
180	Move to node FX
181	Move to node FY

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

Accept
Qty

Reject
QtyReject
Number

**Insp.
Stamp**

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

Q 11-11-14
(90)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 76179

76179

Parent Item: D3067-1

D3067-1

Parent Item Name: End Plate

Start Date: 07/11/2011

Required Date: 21/11/2011

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP: 03.01.21 Remove step 6 (Deburr) KJ
IPP Rev:B Now on Water jet 06-06-16 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M5052H32S.063

Purchased

No

100

sf

50.5000

0.0625

3.947368

M5052H32S 063

1811-11

5052-H32 .063 Sheet

Location

Loc Qty

Loc Code

MAT022

50.5

114322

50.5

114322

90

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

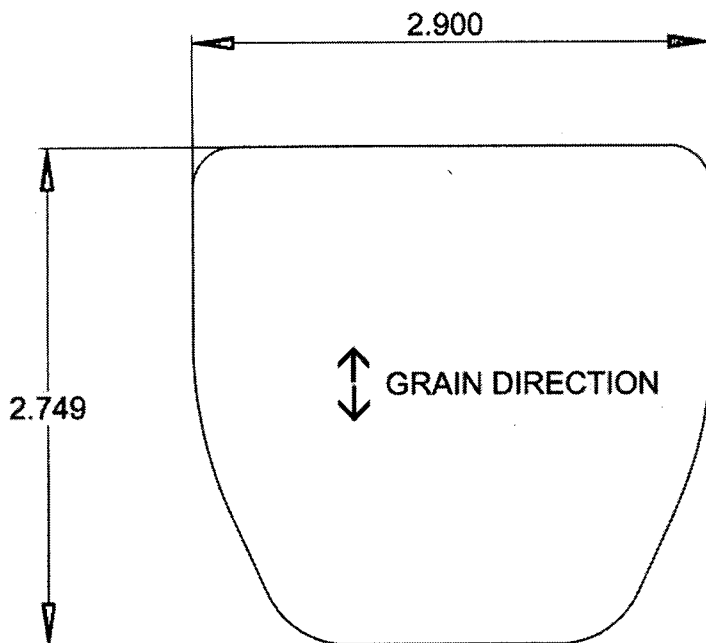
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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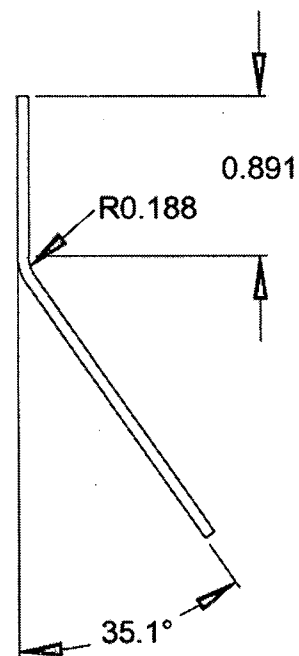


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>CP</i>	DRAWING NO. D3067	REV. A SHEET 1 OF 1
DATE 02.09.11		TITLE END PLATE	SCALE 1:1
A	02.09.11	NEW ISSUE	

RELEASED
02.09.2011



D3067-1 FLAT PATTERN



D3067-1 BEND DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO APPROVAL
WITHOUT NOTICE
WORK ORDER
NO. 74179

11-11-08

D3067-1 END PLATE

- 1) MACHINE PER DWG FILE "D3067-1.SLDPRJT"
- 2) MATERIAL: 5052-H32 PER QQ-A-250/8 (REF DART SPEC. M5052H32S.063)
OR 6061-T6 PER QQ-A-250/11 (REF DART SPEC. M6061T6S.063)
ALUMINUM SHEET, 0.063 THICK
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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